

Date: Monday, 2/25/2008 7:34:01 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	WEARSHOE	
Job Number	37584				
Estimate Number	12737				
P.O. Number	:		Part Number	D353513	
This Issue	2/25/2008	S.O. No. :	Drawing Number	D3535 REV B	
Prsht Rev.	NC		Project Number	N/A	
First Issue	/ /	Type : SMALL /MED FAB	Drawing Revision	B	
Previous Run	36423		Material	:	
Written By	:		Due Date	3/6/2008	Qty: 20 Um: Each
Checked & Approved By	:				
Comment	Est Rev:A New Issue 07-02-15 JLM Est Rev:B As per Rev B 07-08-31 JLM Verified By:EC				

Additional Product

Job Number:



Seq #:

Machine Or Operation:

Description :

1.0

M304S20GA

304/316 .040 Sheet



Comment: Qty.: 0.8930 sf(s)/Unit Total : 17.8605 sf(s)

304/316 .040 Sheet

(M304S20GA)

Batch: 16748

EB 8-2-25

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3535

Dwg Rev: B

EB 8-2-25

26

Prog Rev: B

2-Deburr if necessary

EB 8-2-25

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



EB 8-2-25

26

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



JAN 27 2008

Comment: SECOND CHECK

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on Brake as per Dwg D3535 using Jigs DT8261and DT8326

2-Form joggle as per Dwg D3535 using Jig DT8158Identify as D3535-13

EB 05/03/12 26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/03/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/25/2008 7:34:01 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 37584

Part Number: D353513

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

1 08/03/12 (26)

7.0

POWDER COATING

POWDER COATING



m106442

Comment: POWDER COATING

FL 08/03/13 (26)

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



11

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-03-13 (26)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FL-17

11

03-03-13 (26)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

K 08/03/14

Job Completion



~ 2008/3/13

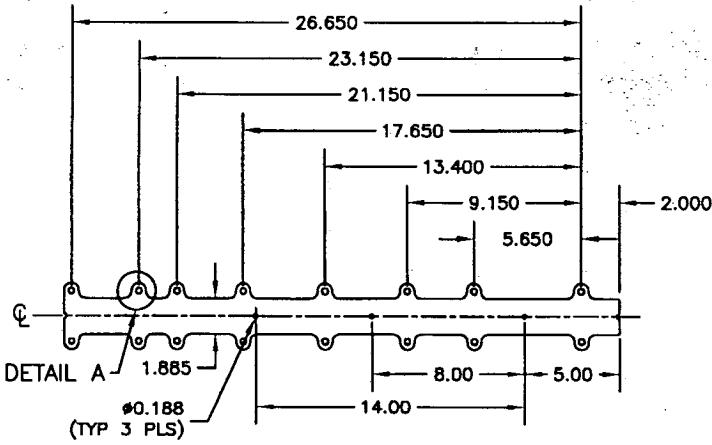
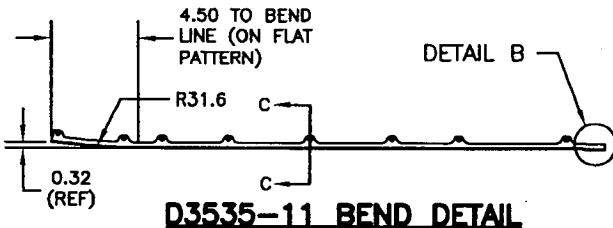
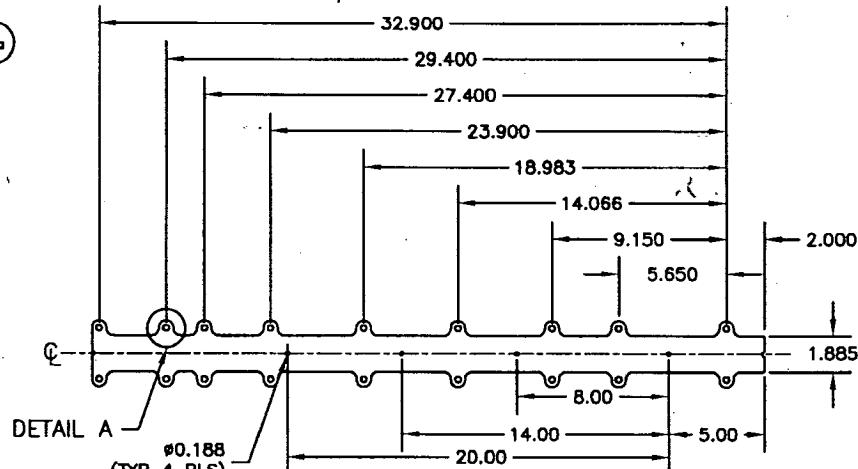
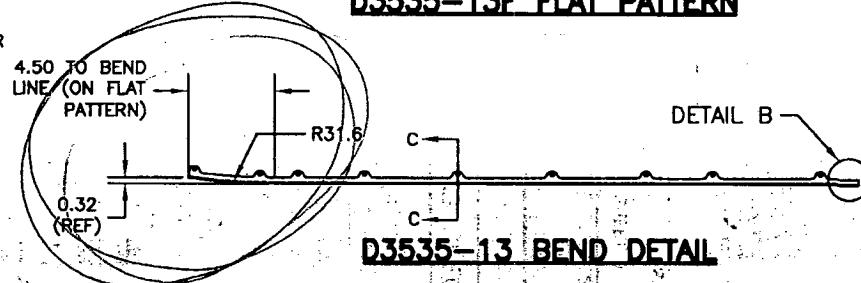
(26)

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL****D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL**

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DESIGN CB	DRAWN BY MH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED MH	APPROVED MH	DRAWING NO. D3535
DATE 07.04.17		SHEET 1 OF 7
A 06.10.25		REV. B
B 07.04.17		TITLE WEARSHOE
		SCALE 1:10
		WORK ORDER NO. <u>31584</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

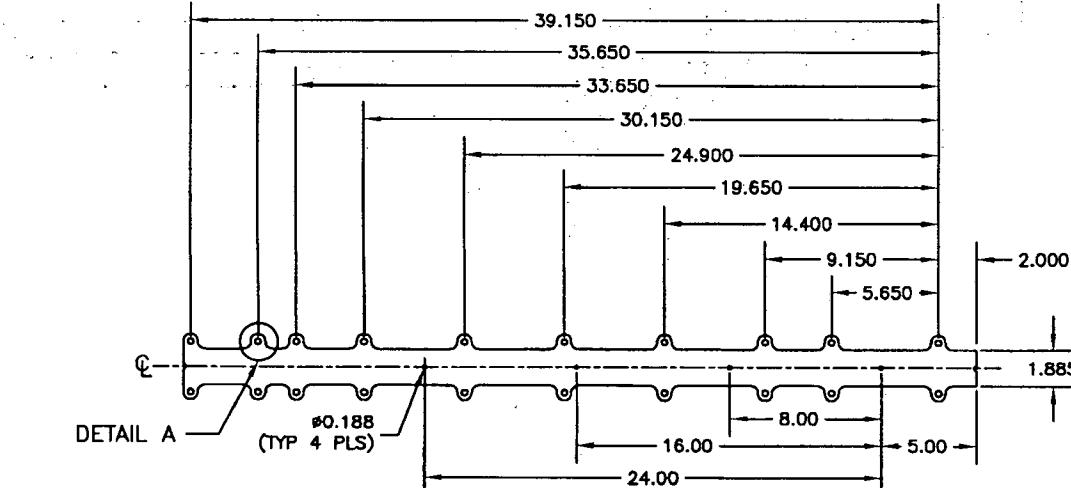
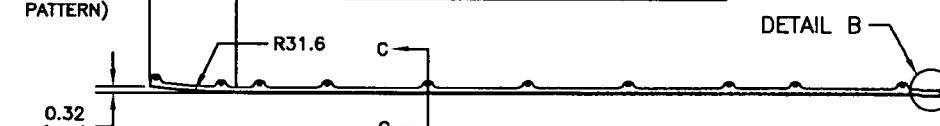
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DARTRELEASED
H

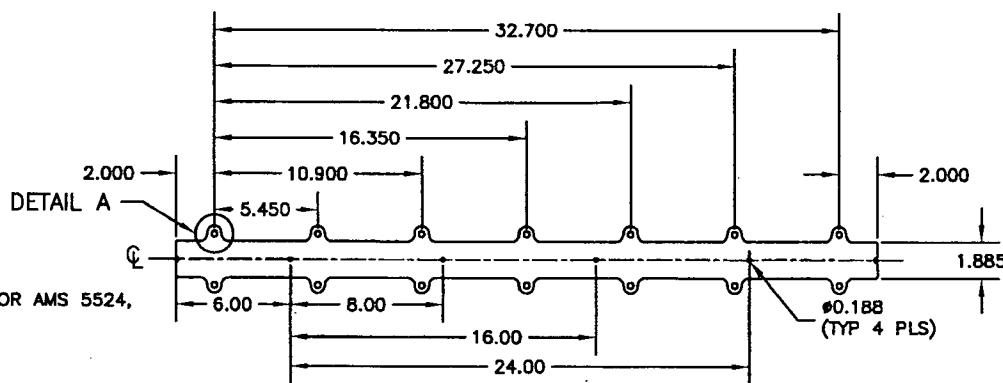
07.04.24

**D3535-15F FLAT PATTERN****D3535-15 BEND DETAIL**

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31584

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{G}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

**D3535-21F FLAT PATTERN****D3535-21 BEND DETAIL**

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	REV. B
CHECKED	APPROVED	DRAWING NO.	SHEET 2 OF 7
DATE		TITLE	SCALE
<i>H</i>	<i>H</i>	D3535 WEARSHOE	1:10
07.04.17			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

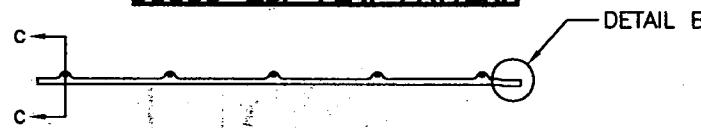
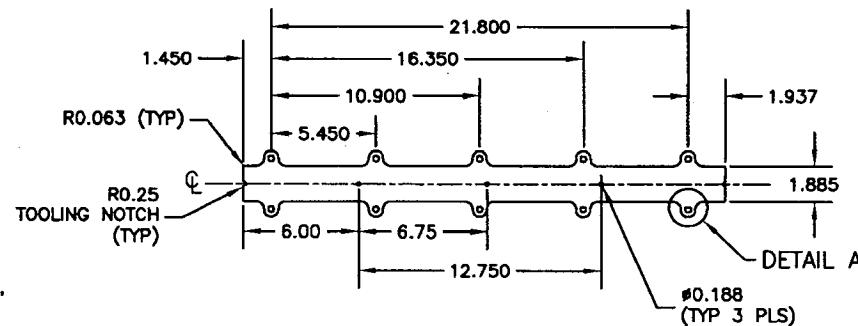
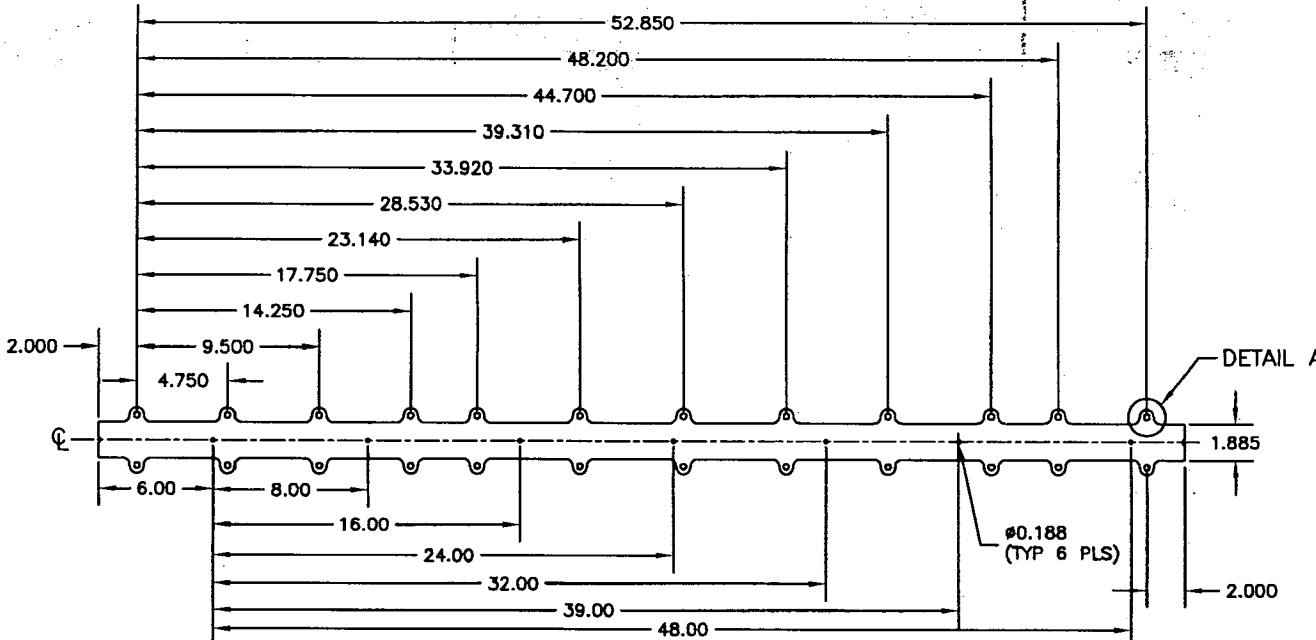
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED H	APPROVED H	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 3 OF 7 SCALE 1:10

RELEASED
07.04.24 **H**

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WITHOUT NOTICE
WORK ORDER
NO. 31584

NOTES

- MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI D05 4.3
- PART IS SYMMETRICAL ABOUT φ
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
- BREAK ALL SHARP EDGES TO 0.010 MAX
- IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- SEE PAGE 7 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

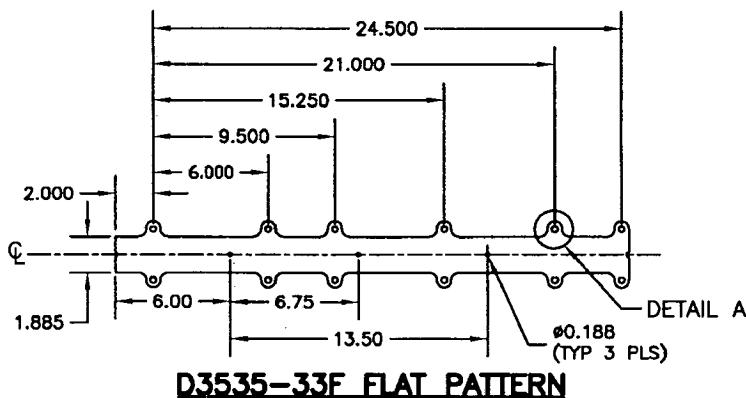
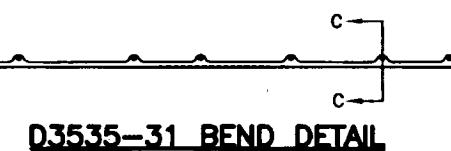
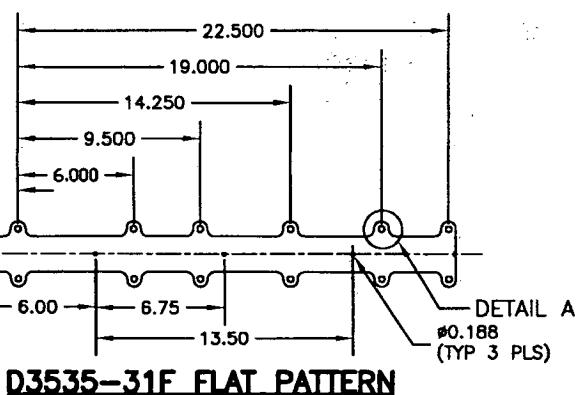
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN C.B	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED MF	APPROVED MF	DRAWING NO. D3535
DATE 07.04.17		TITLE WEARSHOE

REV. B
SHEET 4 OF 7
SCALE 1:10

RELEASED
07.04.29
[Signature]**D3535-33 BEND DETAIL**DETAIL A
#0.188
(TYP 3 PLS)**D3535-31 BEND DETAIL**

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31584

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,
20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT
PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

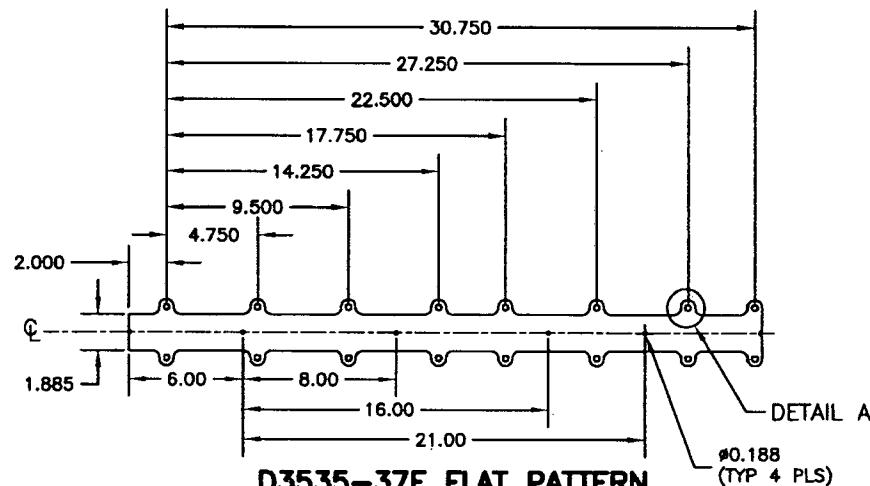
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

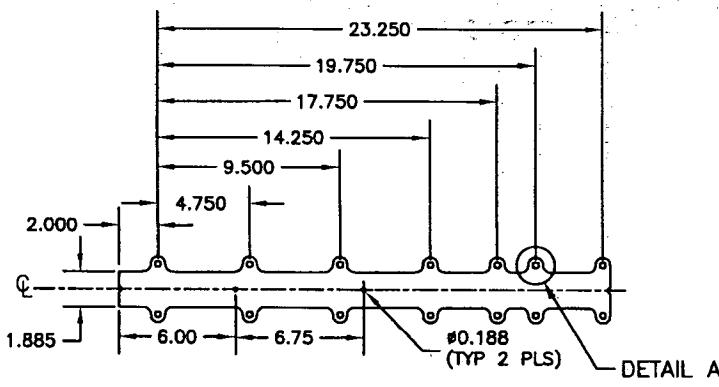
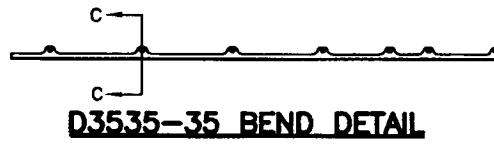
DARTRELEASED
07.04.17

DESIGN C.B	DRAWN BY PY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED MM	APPROVED MM	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 5 OF 7 SCALE 1:10

**D3535-37 F BEND DETAIL**

NOTES
 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,
 20 GAUGE (0.038 THICK)
 (REF DART SPEC M304S20GA)
 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER
 QSI 005 4.3
 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
 4) TOLERANCES ARE PER DART QSI 018 UNLESS
 OTHERWISE NOTED
 5) ALL DIMENSIONS ARE IN INCHES
 6) BREAK ALL SHARP EDGES TO 0.010 MAX
 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT
 PAINT MARKER
 8) SEE PAGE 7 FOR DETAILS AND SECTION

WORK ORDER NO. 3535-37

**D3535-35 F FLAT PATTERN****D3535-35 BEND DETAIL**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

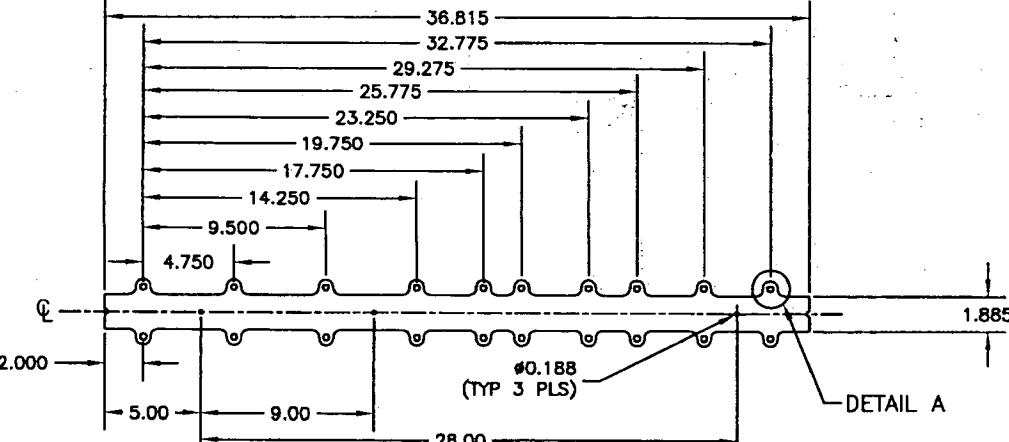
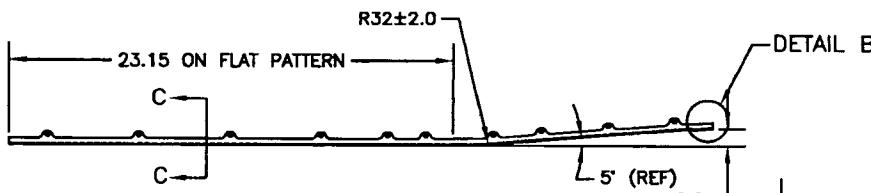
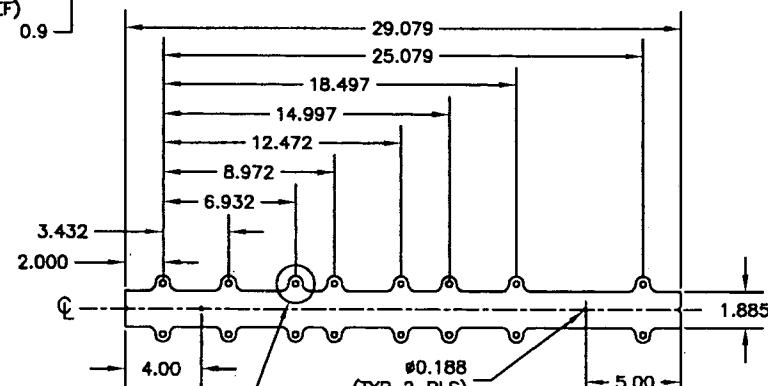
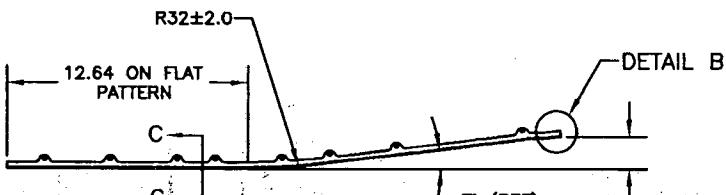
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 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN C.B	DRAWN BY MH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED MM	APPROVED MM	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 6 OF 7 SCALE 1:10

**D3535-39F FLAT PATTERN****D3535-39 BEND DETAIL****D3535-41F FLAT PATTERN****D3535-41 BEND DETAIL**

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{Q}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

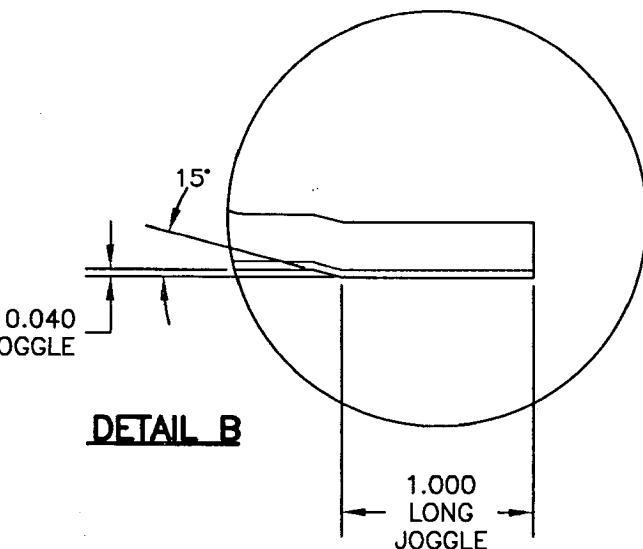
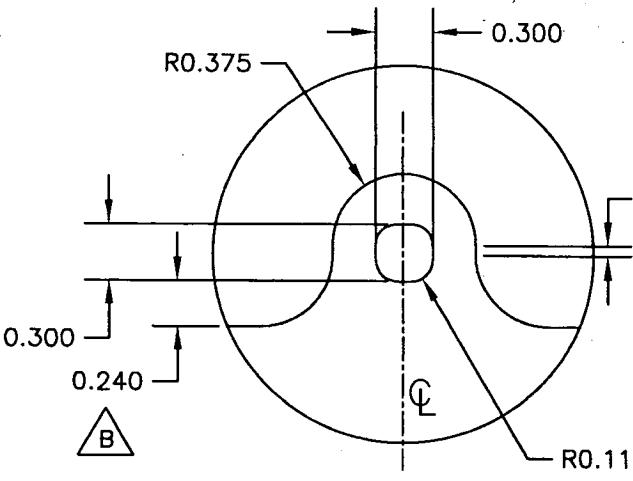
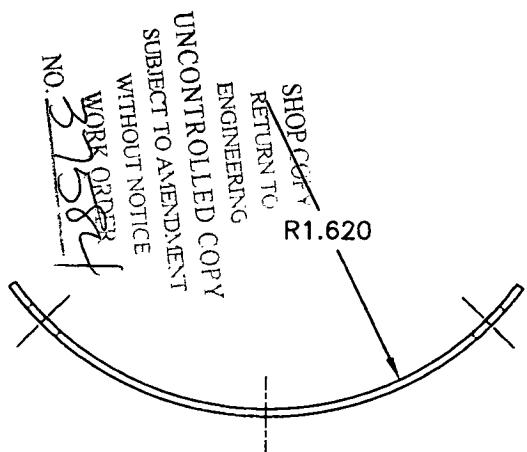
NOTE: Date & initial all entries

DART

DESIGN C-B	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	REV. B
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535	SHEET 7 OF 7
DATE 07.04.17	TITLE WEARSHOE	SCALE 1:1	

RELEASED
[Signature]

07.04.24

**DETAIL B****DETAIL A****SECTION C-C**

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD

Work Order: 37584

Description: WEAR SHOE

Part Number: U3535-13

Inspection Dwg: D3S3S-13 Rev: B

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article

Prototype

Measured by: HR

Audited by:

Prototype Approval:

Date: 8-2-25

Date:

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	